TECHNICAL DATA SHEET

CATEGORY: **WATER SOLUBLE CORED WIRE**

NAME: **WS482 CORED WIRE**

FEATURES

- HALIDE FREE
- FOR STANDARD AND HIGH-TEMPERATURE APPLICATIONS
- EXTENDED CLEANING TIMES- SAFE UP TO 2 TO 3 DAYS
- GOOD THERMAL TRANSFER
- HIGH ACTIVITY LEVEL
- GOOD WETTING PROPERTIES

DESCRIPTION

WS482 is a water soluble, halide-free flux cored wire that is highly active and compatible with water soluble solder paste chemistries. WS482 offers improved thermal stability, allowing it to be processed with standard or high-temperature alloys. WS482 offers residues that are non-corrosive and therefore may be used without cleaning for applications where conductivity will not cause a problem (such as soldering wires). Post-process residues are safe to remain on many assemblies for up to two to three days. WS482 produces excellent tarnish and oxide removal, will not tarnish PCBs, copper, or solder joints, and offers excellent wetting and soldering characteristics. WS482 flux residue is readily soluble in hot water.

HANDLING

- WS482 cored wire has an indefinite shelf life when proper storage conditions are observed
- Store product in a clean dry area away from moisture and sunlight. Do not freeze this product.

APPLICATION

- Solder iron tip temperature should be between 650° - 750°F for Sn63 and Sn62 alloys, 700° - 800°F for Sn/Ag and Sn/Ag/Cu alloys.
- Hold the solder iron at a 45° to 60° angle to the work surface.
- The solder iron should contact both the component lead and PCB pad surface.
- Solder and flux should flow onto both the lead and pad or lead and barrel to promote optimum flux activity to the joint being worked.
- If additional flux is needed, the use of AIM flux dispensing pens is recommended for dispensing precise amounts of flux, eliminating over-saturation.

CLEANING

- Post-process residues should be removed within a two to three day period. Deionized water is recommended for the final rinse. A temperature of 100° - 150°F is sufficient for removing residues. An in-line or other pressurized spray cleaning system is suggested, but is not required.

PACKAGING

- WS482 core wire is standard with a 2.5% flux core.
- WS482 is available in Sn60, Sn62, Sn63, Sn96, Sn/Ag/Cu, SN100C and other custom alloys upon request.
- Standard spool sizes; ½ lb. for .010 and .015 diameters, 1 lb. for .020, .032, .040, .050, and .062 diameters. Other spool sizes and wire diameters are available upon special request.
- Packaging of ½ lb. and 1 lb. spools is standard in 12 lb. and 24 lb. cases.

SAFETY

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **M**aterial **S**afety **D**ata **S**heet for any specific emergency information.
- Do not dispose of any waste materials in non-approved containers.